

Work Order ID 74506

Monday, October 03, 2011 2:35:43 PM



Page 1

Item ID: D3572-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide

Start Date: 9/30/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

M.L.J.

Date: 11/10/03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3572	Rev D								

100

0.00



BAND SAW

F.K. 11/10/19

Bandsaw

Memo

0.00

20 0

Jeaspa Bandsaw

Cut blank .500" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

20 0

HAAS CNC vertical machine #1

1- Mill as per Folio FA685 Rev *AA* & Dwg D3572 Rev: *D* ☐ 2-Deburr *SL 11-10-26*

per dwg D3572

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

SL 11-10-26

20 0

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 2

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

mf 11/10/26

20

0



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

P 11/10/26 20

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/10/27 JG
mf
11-10-26

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Picklist Print

Monday, October 03, 2011 2:35:49 PM

Page 1

Work Order ID: 74506



Parent Item: D3572-3



Parent Item Name: Guide

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
IPP rev B rev.B dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X01.50
0

Purchased

No

f

25.5746

0.800400



6061-T6 Bar .750 X 1.50

Location

Loc Qty

Loc Code

MAT003

25.5746

116405

0.4492

116604

1.5

116623

1.6254

118182

2

✓118844

20

83

PK- 11/10/19

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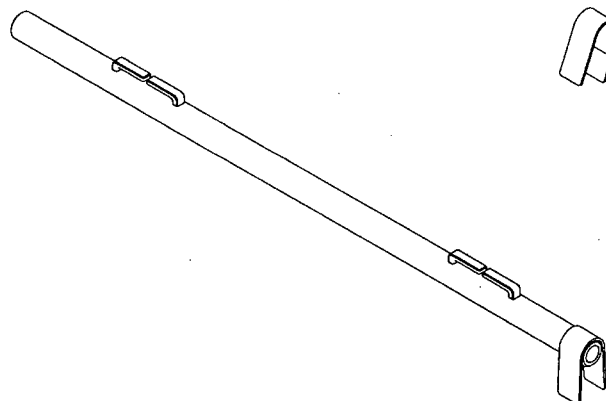
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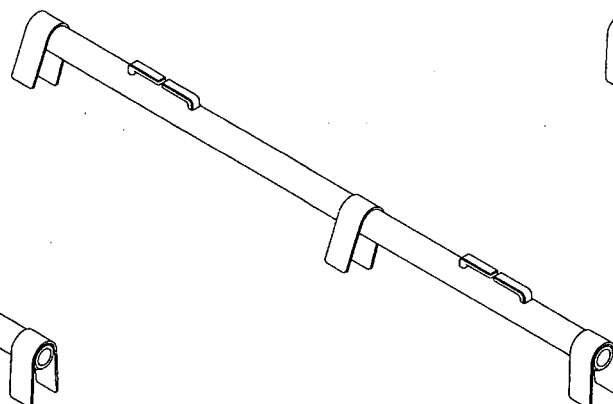
NOTE: Date & initial all entries

ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

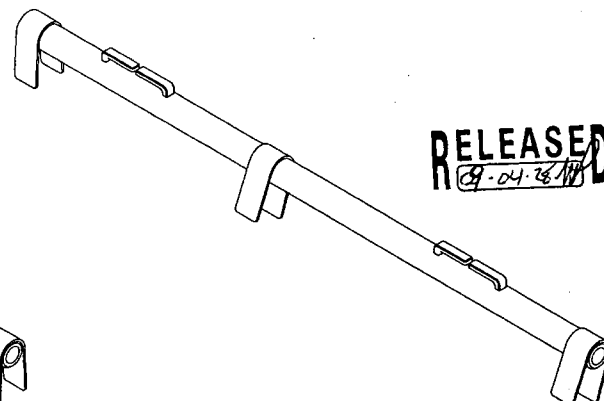
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74506 M.C.J
11/10/03



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

RELEASED
09-04-28/11

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
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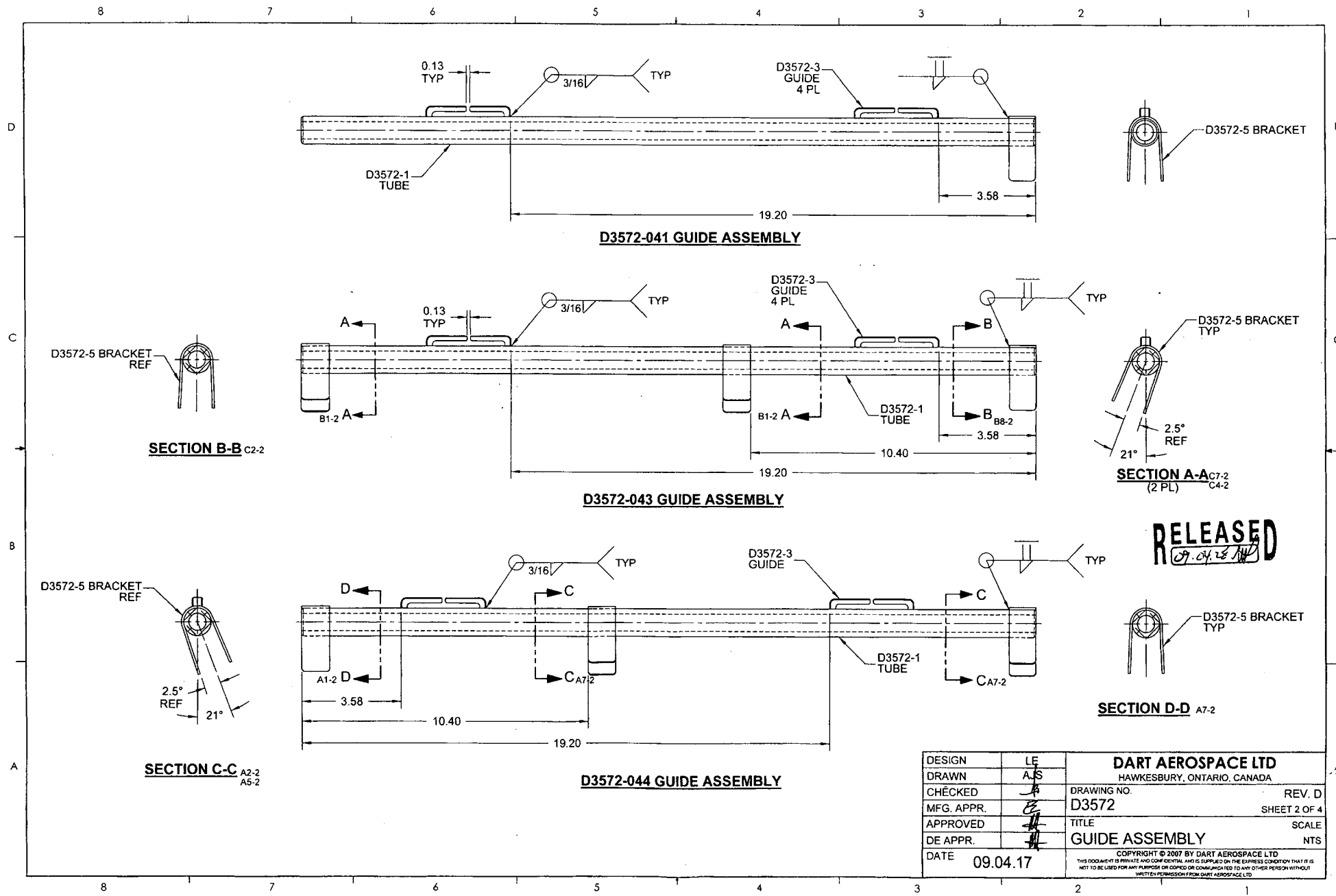
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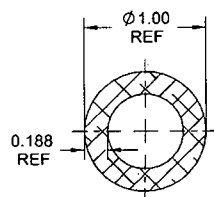
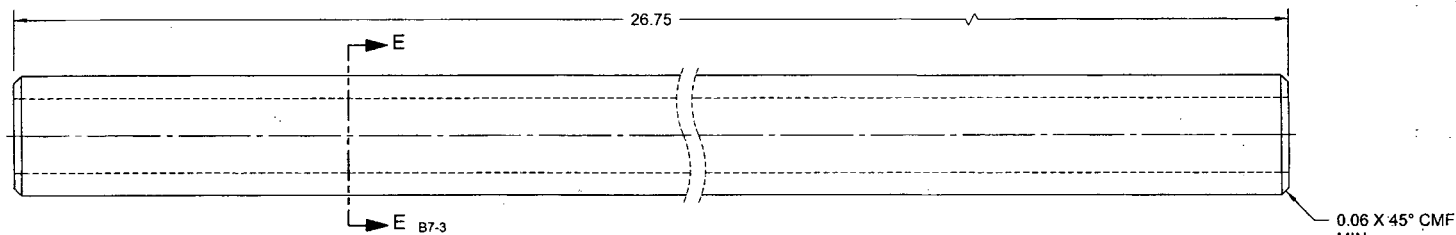
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74506

**SECTION E-E** C5-3**D3572-1 TUBE****RELEASED**
07/04/17 MP**D3572-1 NOTES:**

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

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MFG. APPR.	[Signature]	D3572	SHEET 3 OF 4
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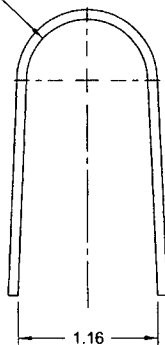
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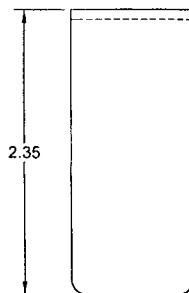
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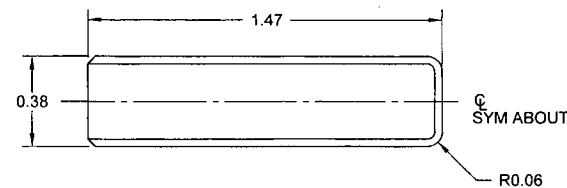
R0.50



2.35

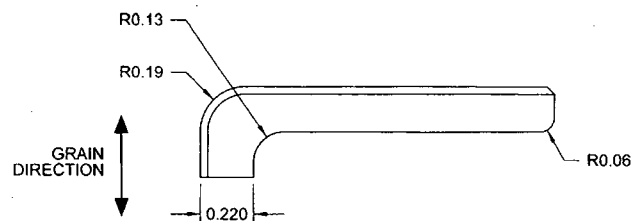


D3572-5 BRACKET
(MAKE FROM D3572-5F)



SYM ABOUT

R0.06

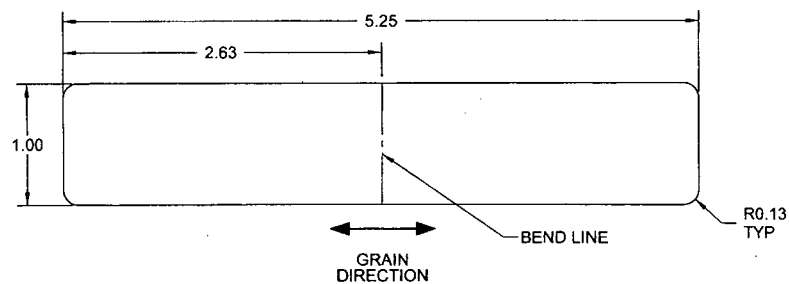


0.03 X 45°

R0.06

SYM ABOUT

D3572-3 GUIDE



D3572-5F FLAT PATTERN

RELEASED
9/4/83

D3572-3 NOTES:

1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: 0.04 lbs

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